

Date: Monday, 27/04/2009 11:35:44 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 47549		
Estimate Number	: 10285		
P.O. Number	:	Part Number	: D2565111
This Issue	: 27/04/2009 S.O. No. :	Drawing Number	: D2565 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 27/04/2009 Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 47486	Material	:
Written By	:	Due Date	: 04/05/2009 Qty: 18 Um: Each
Checked & Approved By	: <u>JULIE DAWSON</u>		
Comment	: Est: E 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC Est: E 06.05.03 Change level 2/8 to QC5 EC		

## Additional Product



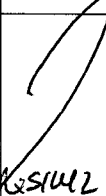
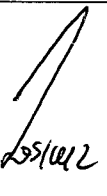
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
Comment: Qty.: 1.1944 f(s)/Unit Total: 21.4988 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: <u>M111091</u>		
2.0	BRAKE NC	NC BRAKE
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr and polish		
4.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3  START TIME: <u>7:50</u> OVEN TEMPERATURE: <u>400°</u> FINISH TIME: <u>8:20</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-111 PAR #: N/A Fault Category: Prod/Insassy med & small NCR: (Yes) No DQA: D Date: 08/05/20  
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/05/20

NCR: <u>47549</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/4/30	2.0	Parts Found 2 be 1.00" no short. RC Human error.		Lade incorrect struts with mat # AND Batch # <del>AND Put Aside to use for</del> D2565-409 (short struts).	4/10 47899 SB 09/05/12	S 09/05/13		S 09/04/30
				Replace B# <del>47899</del> <u>48</u> <del>22199-3</del> <u>B 47899</u> <u>x10</u> M11457	SB 09/05/12	S 09/05/13		S 09/04/30

NOTE: Date & initial all entries

Date: Monday, 27/04/2009 11:35:44 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 47549

Part Number: D2565111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(18)

Comment: INSPECT POWDER COAT

FL 09/05/04

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 270

At 09/05/14 (18)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/14 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-05-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

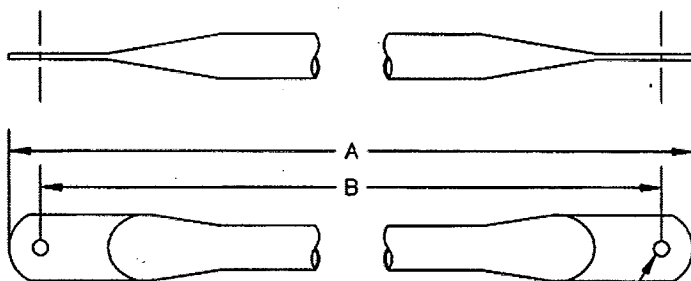
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
	11	Parts Found to be too short by 1/16". P.C. Hummer error.						

NOTE: Date & initial all entries



DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

**RELEASED**  
04.05.05



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL (REF DART SPEC. M304TR0.750W0.049) ENSURE SEAMLESS TUBE IS USED
- FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING

SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

Copyright © 1996 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries